

Date: Monday, 5/1/2006 4:23:31 PM
 User: Kirby Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END PLATE
Job Number	: 26913		
Estimate Number	: 10403		
P.O. Number	: N/A	Part Number	: D2405
This Issue	: 5/1/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2405 REV. A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: N/A
Written By	: <i>See COMMENT BELOW</i>	Due Date	: 6/30/2006
Checked & Approved By	: <i>06.05.02</i>	Qty:	14 Um: Each
Comment	: Est: C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.2441 sf(s)/Unit Total : 3.4178 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: *m19296*

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 5.700" x 5.340"

N/A
06.05.15

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA160 and Dwg D2405

Stack of 7

Identify as D2405

Water Jet
AS per Dwg

06.05.18
ml 06 05 23

PTO

14
8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 05 23
14

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

N/A

P


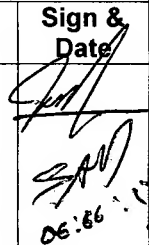
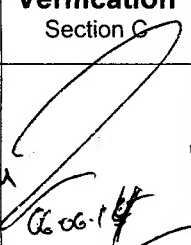

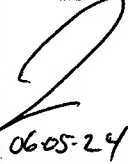
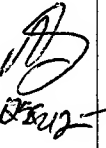
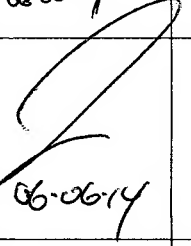
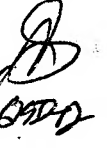

See QCS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-24	3	Parts were cut too long, cut out to 02415 → 7.250, due to the an error in the water jet ratio.		re-adjust the DXF. Scribe and shear parts, to correct size as per Dwg.	 06-06-14	 06-06-14	 06-05-24	 06-05-24
06-06-14	Nil step 3	2 part were to short cut with the shear.		Scrap: destroy	SAD 06-06-14	 06-06-14	 06-06-14	 06-06-14

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: END PLATE

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Part Number: D2405

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

SAD

06:06:14

(12)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06:06:15

(12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 43

PO 6/6/16

(12)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/16

(12)

Job Completion



u 06:06:19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

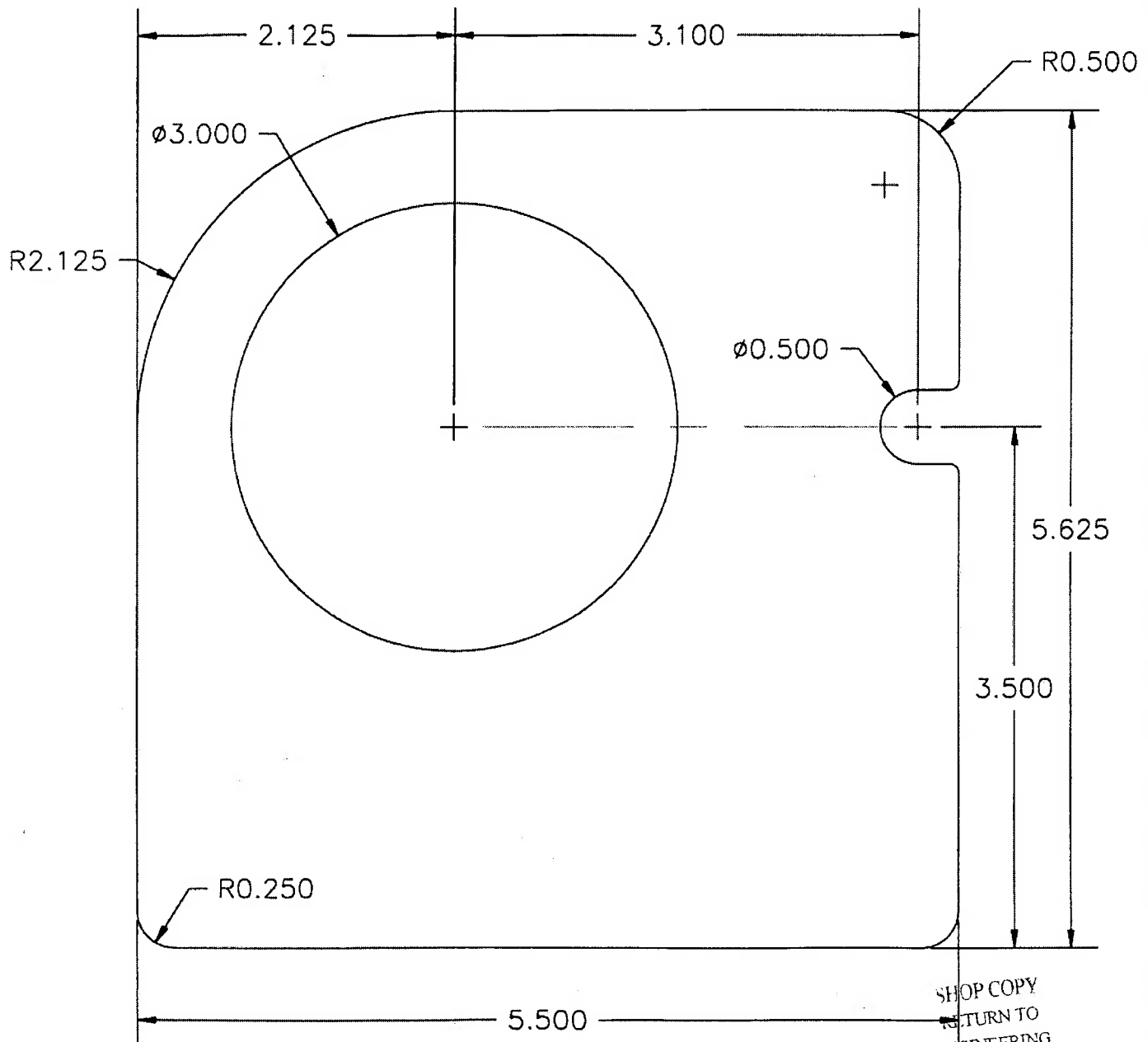
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2405	REV. A SHEET 1 OF 1
DATE Apr. 6, 1995		TITLE 206 END PLATE	SCALE 1:1



RELEASED
96/09/10 BW

MATERIAL: 5052-H34 0.063 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26913